

Thursday, 16/08/2007 11:32:14 AM

ms-Locelle

Process Sheet

Split
Wo 8B 07/08/20

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Part Number	: 34018	Part Number	: D2804042
Estimate Number	: 10334	Drawing Number	: D2804 REV C
Doc Number	: <i>N/A</i>	Project Number	: N/A
Issue	: 16/08/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: C
Rev	: NC	Material	: <i>N/A</i>
Issue	: <i>N/A</i> Type : R & D SM/MED FAB	Due Date	: 05/09/2007
Previous Run	: 29409	Qty:	<i>7</i> Um: Each
Prepared By	: 		
Checked & Approved By	: 		
Part	: Est F 05/03/30 MS21043-3 was MS21042L3 KJ/JLM		
	: Est Rev G As per Rev C 06-11-08 JLM		

Additional Product

Part Number



Seq. #: Machine Or Operation: Description:

1.0 D28042 STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-2	Bracket	<i>B 28413</i>

mf 07-08-28

2.0 D28052 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	<i>B 33600 x 3mm, B 34033 x 4mm</i>

07-08-28
mf

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	<i>B34035 x7</i>

mf

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 & D2809 into arm as per Dwg D2804

mf 07-08-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/03/20	1	Split W/O	SAS	07/03/20	7		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34018

Part Number: D2804042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.C	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28 (+7)

6.C	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

u
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M 102316
Green Sandtex*

m-f 07/08/29

7.C	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/08/29 (x7)

8.C	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Press Fit D2809 as per Dwg D2804

m-l 07/08/29

9.C	AN3C16A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: *14* 40.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

M101884

SP

*Correction
disinventaire
à faire*

10.C	MS210433	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: *14* 40.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

MS21043-3 Nut

M104955

SP

11.C	NAS1515H3	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: *28* 80.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H3

Washer

M100993

7/8/29 SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34018

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R

LPS-3

Corrosion Spray

M 10/9/29

ml

12.

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

ml 07/08/29 x7

13.

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/08/29 (7)

14.

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 07-08-30

15.

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(7) 07/08/31

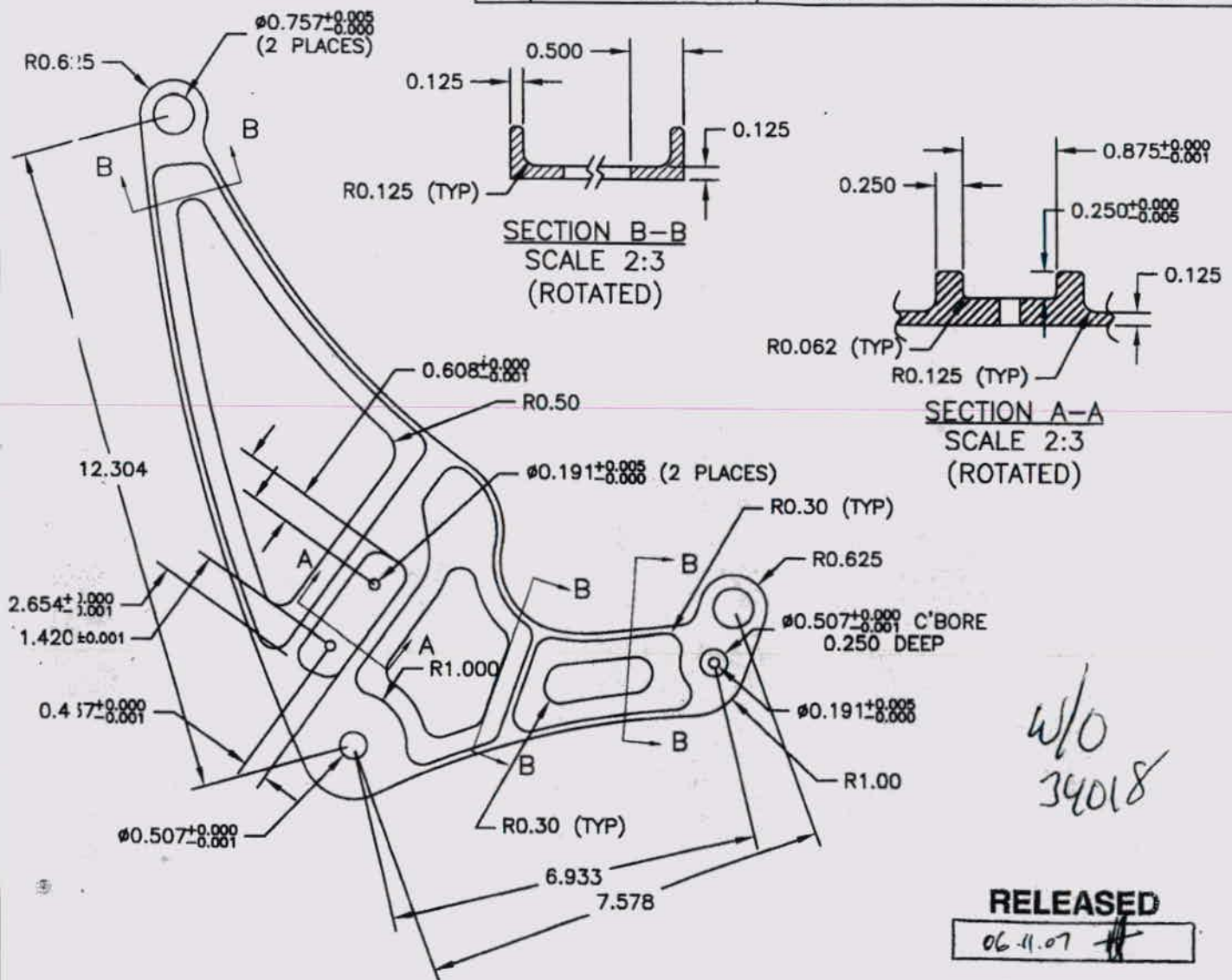
Job Completion



W 07-08-31

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

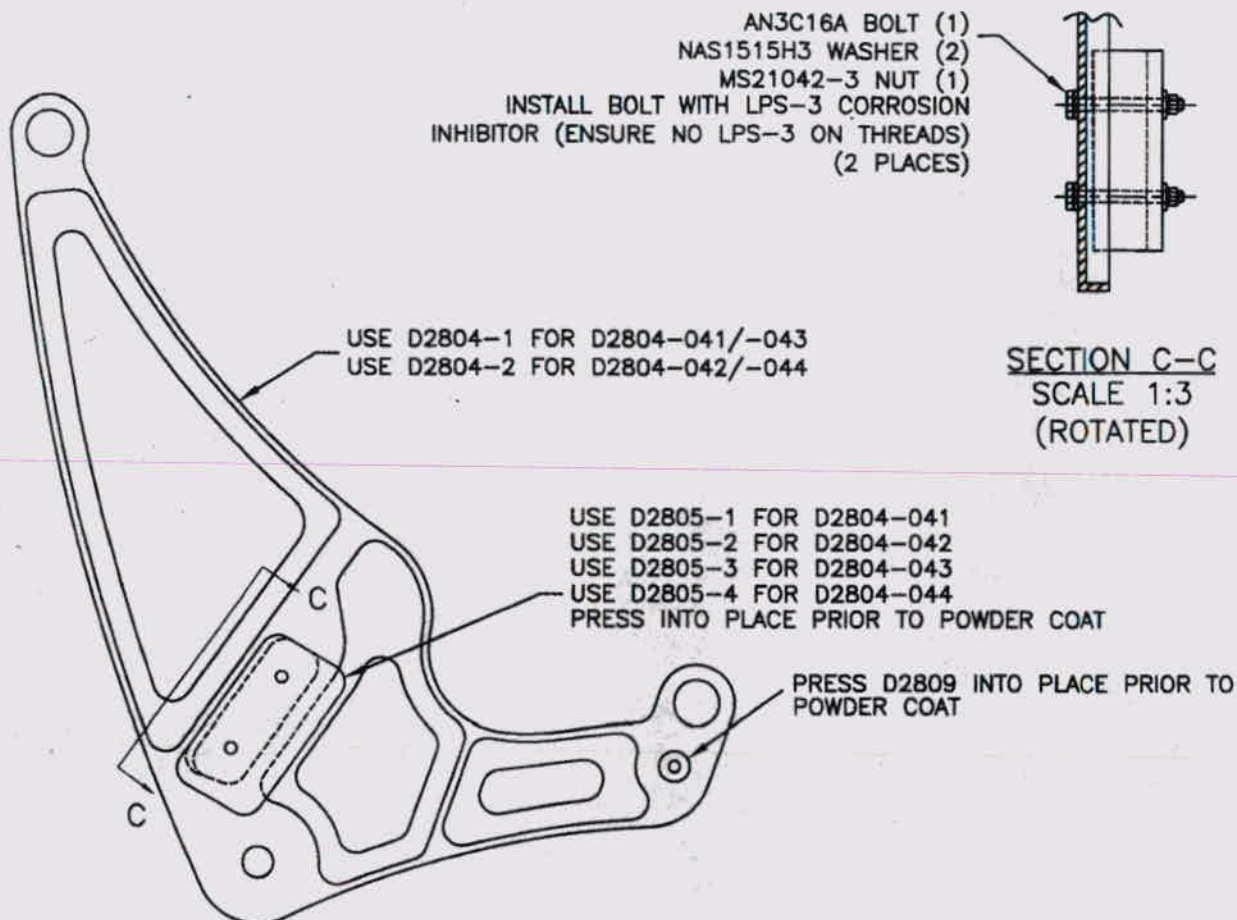
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

**RELEASED**

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN)**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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